

MIG Set-Up Guide

1 SELECT PROCESS	a MATERIAL SELECTION	b WELDING WIRE TYPE	c SHIELD GAS TO BE USED	d MATERIAL THICKNESS	115 VAC / 30A Electrical Outlet*						230VAC							
					115 VAC / 20A Electrical Outlet													
					115 VAC / 15A Electrical Outlet						24 ga. (0.6 mm)	22 ga. (0.8 mm)	18 ga. (1.2 mm)	16 ga. (1.6 mm)	1/8" (3.2 mm)	3/16" (4.7 mm)	1/4" (6.4 mm)	3/8" (9.5 mm)
MIG	Mild Steel	ER70S-6 .023" (0.6 mm)	75% Ar, 25% CO ₂	2 Wirespeed Display 3 Voltage Display 4 Inductance Display	194 13.8 10	255 15 8	287 16.7 6	400 19 10	- - -	- - -	-	194	255	287	457	522	600	-
	Mild Steel	ER70S-6 .030" (0.8 mm)	75% Ar, 25% CO ₂	2 Wirespeed Display 3 Voltage Display 4 Inductance Display	142 13.7 10	174 15 10	219 16 8	268 18 10	- - -	- - -	139	152	168	220	274	326	484	600
	Mild Steel	ER70S-6 .035" (0.9 mm)	75% Ar, 25% CO ₂	2 Wirespeed Display 3 Voltage Display 4 Inductance Display	142 12.9 10	165 14 10	178 14.8 10	226 19 10	293 - -	- - -	-	139	165	178	226	281	326	432
	Mild Steel	ER70S-6 .023" (0.6 mm)	100% CO ₂	2 Wirespeed Display 3 Voltage Display 4 Inductance Display	219 11.4 8	277 15.5 8	281 17 6	- - -	- - -	- - -	-	249	278	290	500	600	-	-
	Mild Steel	ER70S-6 .030" (0.8 mm)	100% CO ₂	2 Wirespeed Display 3 Voltage Display 4 Inductance Display	139 12.9 10	168 15.5 10	197 17 10	300 19 10	- - -	- - -	-	139	168	197	300	393	464	600
	Mild Steel	ER70S-6 .035" (0.9 mm)	100% CO ₂	2 Wirespeed Display 3 Voltage Display 4 Inductance Display	123 13 8	152 16.5 10	174 17.5 10	226 19 10	- - -	- - -	-	123	152	174	213	278	290	-
	Mild Steel	E71T-11 .030" (0.8 mm)	Self Shielding	2 Wirespeed Display 3 Voltage Display 4 Inductance Display	- - -	149 13.5 10	191 15 10	255 17.5 10	274 19 10	- - -	-	-	149	191	255	274	300	400
	Mild Steel	E71T-11 .035" (0.9 mm)	Self Shielding	2 Wirespeed Display 3 Voltage Display 4 Inductance Display	- - -	113 13.2 8	139 13.5 10	200 15 10	255 16.8 10	300 18 10	-	-	113	139	200	255	300	377
	Mild Steel	E71T-11 .045" (1.2 mm)	Self Shielding	2 Wirespeed Display 3 Voltage Display 4 Inductance Display	- - -	- - -	- - -	- - -	- - -	- - -	-	-	-	107	129	108	200	242
	Stainless Steel	ER308L / ER316L .030" (0.8 mm)	Tri-Mix 90% He, 7.5% Ar, 2.5% CO ₂	2 Wirespeed Display 3 Voltage Display 4 Inductance Display	101 10 10	162 17 6	181 17.6 6	- - -	- - -	- - -	-	101	162	181	281	300	390	432
STICK	Stainless Steel	ER308L / ER316L .035" (0.9 mm)	Tri-Mix 90% He, 7.5% Ar, 2.5% CO ₂	2 Wirespeed Display 3 Voltage Display 4 Inductance Display	- - -	149 16.2 2	174 18 2	- - -	- - -	- - -	-	-	149	175	220	300	316	348
	Aluminum Use Spool Gun	ER4043 .035" (0.9 mm)	100% Argon	2 Wirespeed Display 3 Voltage Display 4 Inductance Display	- - -	322 13.7 2	345 15.4 2	400 16.5 2	- - -	- - -	-	-	322	345	400	554	600	-
	Aluminum Use Spool Gun	ER4043 3/64" (1.2 mm)	100% Argon	2 Wirespeed Display 3 Voltage Display 4 Inductance Display	- - -	203 13.2 2	255 13.9 2	297 15.8 2	- - -	- - -	-	-	204	255	297	316	339	352

*Refer to operating manual

Note: MIG set-up guide parameters are given as a reference. Optimal settings may vary depending upon welding position, joint design, and wire/gas compositions.

Fabricator 2iii Set-up Guide

THERMAL ARC

LIFT TIG Set-Up Guide

Note: LIFT TIG set-up guide parameters may vary depending upon welding position, joint design. (MS=Mild Steel SS= Stainless Steel)

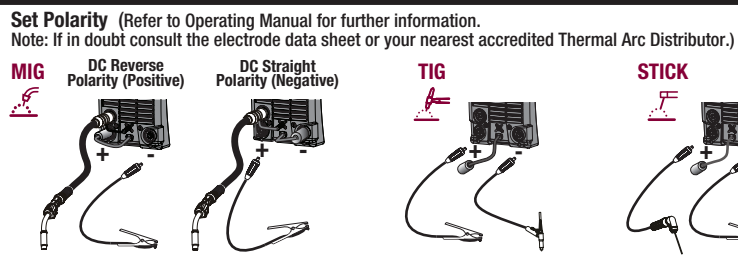
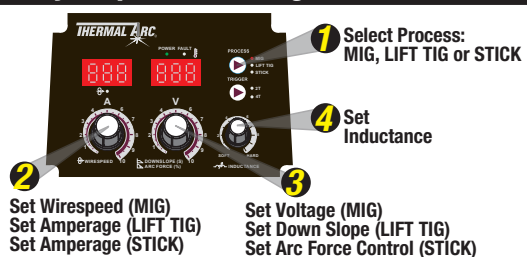
1 SELECT PROCESS	a MATERIAL SELECTION	b TUNGSTEN DIAMETER	c FILLER ROD (If Required)	d SHIELD GAS	e AMPERAGE RANGE
LIFT TIG	Mild & Stainless Steel	1/16" (1.6 mm)	1/16" (1.6 mm)	Argon	2 Amperage Display (MS) Min-115 (SS) Min-70
		3/32" (2.4 mm)	3/32" (2.4 mm)	Argon	2 Amperage Display (MS) 115-170 (SS) 65-150
		1/8" (3.2 mm)	1/8" (3.2 mm)	Argon	2 Amperage Display (MS) 160-200 (SS) 135-180

STICK Set-Up Guide

Note: STICK set-up guide parameters may vary depending upon welding position, joint design.

1 SELECT PROCESS	a ELECTRODE SELECTION	b ELECTRODE DIAMETER	3/32" (2.4 mm) Range Optimum	1/8" (3.2 mm) Range Optimum	5/32" (4.0 mm) Range Optimum
STICK	E6011	2 Amperage Display	60-85	70	90-125
		3 Arc Force Knob	-	50%	100
	E6013	2 Amperage Display	55-90	75	90-135
		3 Arc Force Knob	-	50%	115
	E7018	2 Amperage Display	65-100	85	95-150
		3 Arc Force Knob	-	50%	125
	E7014	2 Amperage Display	55-100	80	95-140
		3 Arc Force Knob	-	50%	120
	E7024	2 Amperage Display	85-120	100	130-170
		3 Arc Force Knob	-	50%	150
STICK	E308L-16 E316L-16	2 Amperage Display	40-70	60	75-110
		3 Arc Force Knob	-	50%	90
		2 Amperage Display	110-150	130	165
		3 Arc Force Knob	-	50%	150

Easy Steps For Welding



Tweco® MIG Gun Consumables

Item	Part Number	Torch Parts Description
1	1210-1112	Nozzle, 1/2" (12.7 mm)
2	1110-1100	Contact Tip, .023" (0.6 mm)
	1110-1101	Contact Tip, .030" (0.8 mm)
	1110-1102	Contact Tip, .035" (0.9 mm)
	1110-1103	Contact Tip, .040" (1.0 mm)
	1110-1104	Contact Tip, .045" (1.2 mm)
	1110-1213	Contact Tip, 3/64" AL (1.2 mm)

Item	Part Number	Torch Parts Description
3	1510-1101	Gas Diffuser
	1420-1103	Liner, .023" (0.6 mm) Hard Wire
	1420-1113	Liner, .030"- .035" (0.8 mm-0.9 mm) Hard Wire
	1420-1123	Liner, .040"- .045" (1.0 mm-1.2 mm) Hard Wire
	1420-1003	Liner, .030"-3/64" (0.8 mm-1.2 mm) AL Wire
	1023-1257	Tweco WeldSkill 220A MIG Gun, 12 ft, .030"- .035" Wire Setup

Drive Rolls

Part Number	Feed Roll Type
W4014800	.023" / .035" (0.6 / 0.9 mm) V Groove (Hard)
7977036	.023" / .030" (0.6 / 0.8 mm) V Groove (Hard)
7977660	.035" / .045" (0.9 / 1.2 mm) V Groove (Hard)
7977731	.030" / .035" (0.8 / 0.9 mm) U Groove (Soft)
7977264	.040" / 3/64" (1.0 / 1.2 mm) U Groove (Soft)
7977732	.030" / .035" (0.8 / 0.9 mm) V Groove Knurled (Flux-Cored)
704277	.045" (1.2 mm) V Groove Knurled (Flux-Cored)

This set-up information is intended to act as a guide only. Please refer to operating manual for further information.

831593_AA